

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023322**Date Inspected:** 24-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:****Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:****Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** N/A**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Trial Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) Trial Assembly Areas

3AW to 3BW

This Quality Assurance (QA) Inspector witnessed final tension verification for Side Panel Splice Plate for Segment 3AW to 3BW between PP 22 to 23. Inspected 10% of bolt final tensioning found satisfactory for Counter Weight side except 1st T-rib from the Longitudinal Stiffener at PP22 as no splice plate at location as the Longitudinal Stiffener weld is been flame cut and to have a room to do welding. Bolt sizes used are M22x 70 RC Lot No. DHGM220020 final Torque required was 520 N-m. Manual calibrated torque wrench is been used bearing Sr. No. X02-584.

3AW to 3BW

This Quality Assurance (QA) Inspector witnessed final tension verification for Side Panel Splice Plate for Segment 3AW to 3BW between PP 22 to 23. Inspected 10% of bolt final tensioning found satisfactory for Cross Beam side. Bolt sizes used are M22x 70 RC Lot No. DHGM220020 final Torque required was 520 N-m. Manual

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calibrated torque wrench is been used bearing Sr. No. X02-584.

3AW to 3BW

This Quality Assurance (QA) Inspector witnessed final tension verification for Bottom Panel Splice Plate for Segment 3AW to 3BW between PP 22 to 23. Inspected 10% of bolt final tensioning found satisfactory. Bolt sizes used are M22x 65 RC Lot No. DHGM220021 final Torque required was 543 N-m. Manual calibrated torque wrench is been used bearing Sr. No. X02-584.

4BW to 5AW

This Quality Assurance (QA) Inspector carried out joint survey along with ABF dimension team headed by Mr. Levi for the U-Rib for 2 Point survey recorded the dimension for all of the 39 U-Ribs and from top of the deck panel recorded the offset.

5AE to 5BE

This Quality Assurance (QA) Inspector carried out joint survey along with Mr. Manikandhan for the U-Rib for 4 Point survey recorded the dimension from 1 to 24 and dimension activity was been put to halt as I proceeded with Bolting Notification.

2AE to 2BE

This Quality Assurance (QA) Inspector randomly witnessed in-progress snug tightening for Upper Chevron from PP # 15, PP # 16 to PP 17 for North and South side.

2AW to 2BW

This Quality Assurance (QA) Inspector randomly witnessed in-progress snug tightening for Upper Chevron from PP # 16 for North and South Side.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Math,Manjunath

Quality Assurance Inspector

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Reviewed By: Miller,Mark

QA Reviewer